

Work Order ID 68428

Wednesday, April 13, 2011 10:05:07 AM

April 18th 19th

Page 1

Item ID: D3198-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 4/13/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: MC Date: 11-4-13 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3198	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3198 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary11-4-13(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-4-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11 04 13 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68428

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Revision ID:

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Item Name: Fitting

Start Date: 4/13/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr if necessary ☐ 2-Form as per Dwg D3198

0.00

0.00

SB 11/04/14



140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

m 11 04 14 (6)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M115128.

Memo

START TIME:

30° FINISH TIME:

0.00

0.00

OVEN TEMPERATURE:

10:30

6 11-4-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68428

Wednesday, April 13, 2011 10:05:07 AM

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Item ID: D3198-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Fitting

Start Date: 4/13/2011 Start Qty: 5.00

Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 1 11/4/11

170

Identify as per dwg & Stock Location: 246A

0.00



Packaging

Memo

0.00

Packaging

11/4/11 60

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11 1911/4/11

Picklist Print

Wednesday, April 13, 2011 10:05:03 AM

Page 1

Work Order ID: 68428



Parent Item: D3198-1



Parent Item Name: Fitting



Start Date: 4/13/2011

Required Date: 4/13/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A 03.11.11 New Issue KJ/RF
IPP Rev:B Now on Waterjet 07-01-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	5.2500	0.105	0.552632			
													

WB11-4-13

Location

Loc Qty

Loc Code

MAT020

5.25

116623

5.25

116623

⑥

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

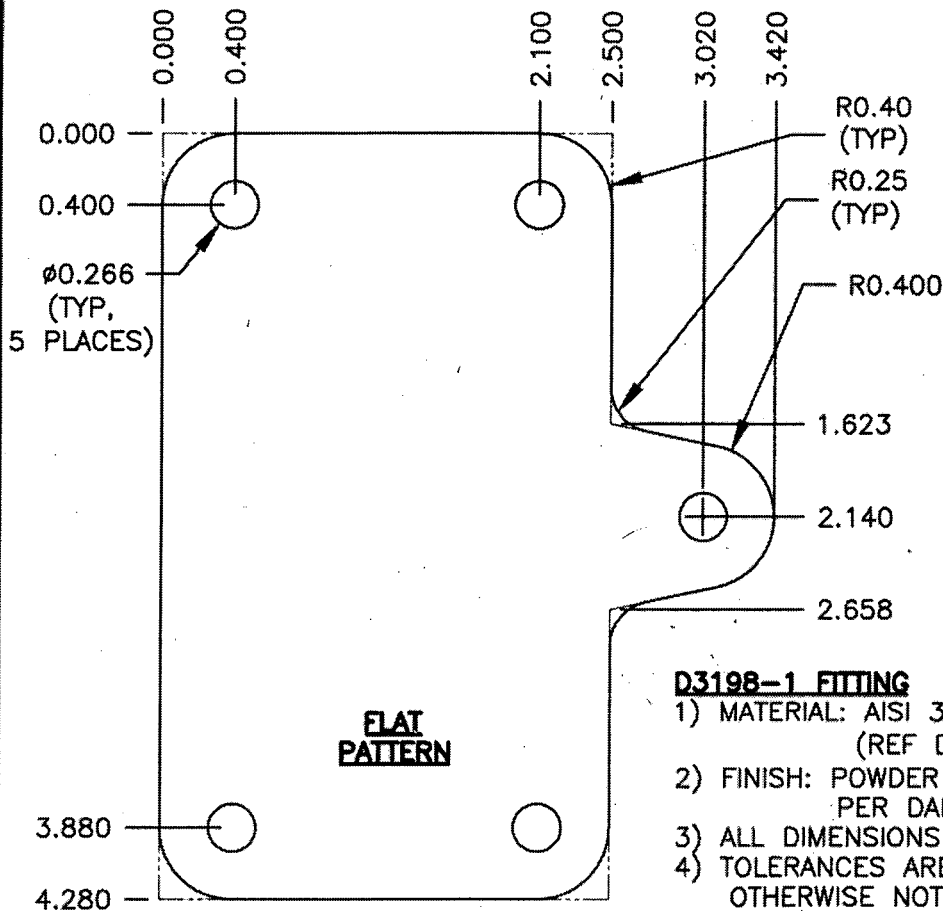
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



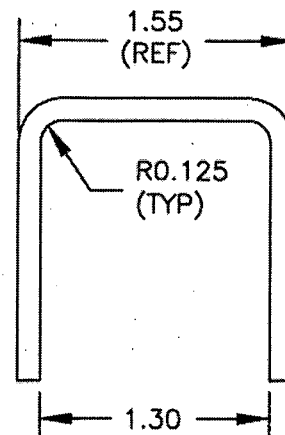
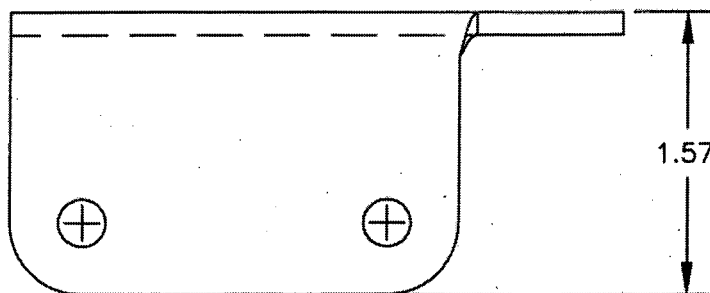
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3198	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	



D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED
03.10.10 *[Signature]*



**BEND
DETAIL**

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